

Amendments to the Claims:

The following listing of claims will replace all prior versions, and listings, of claims in the application:

1-2. (Cancelled)

3. (Currently Amended) A method of manufacturing a tire having, on at least one side wall, a first color side wall rubber expressed as characters or lines, second color side wall rubbers, each of which is located on both sides in the radial direction of this first color side wall rubber, and a second color cover rubber covering the first color side wall rubber portion other than the characters or lines, comprising:

winding a continuous second color rubber ribbon and a continuous first color rubber ribbon in plural turns to stamp each of the second color side wall rubbers and the first color side wall rubber on the side face of a carcass member formed in the toroidal state,

winding a rubber sheet in one turn in the annular state to stamp said cover rubber on the outside of the first and second side wall rubbers by winding so as to shape a green tire, comprising the steps of:

holding a leading end of a long rubber sheet arranged on a tangent of an annular band on the side wall rubber to be a stamping face of said cover rubber;

moving and pressing the leading end onto the annular band;

stamping the rubber sheet onto the annular band by rotating the carcass member around a central axis thereof while applying a tension to the rubber sheet;

cutting off an unstamped portion of the long rubber sheet to form a rear end of the rubber sheet on the annular band and a leading end of a next rubber sheet; and

pressing the formed rear end of the rubber sheet onto the annular band to stamp the cover rubber;

vulcanizing the green tire, using a mold having a recess portion corresponding to the characters or lines, and forming a projecting portion corresponding to the recess portion on the tire, and

after vulcanization, buffing the projecting portion on the tire to have the first color characters or lines to be expressed, A method of manufacturing a tire according to claim 2, wherein

in cutting the long rubber sheet extending on said tangent to form the leading end and the rear end of said rubber sheet, both cut-off faces of the leading end and the rear end of the rubber sheet are inclined with respect to the width direction of the long sheet, and the long rubber sheet is cut off so that, in the cut-off face of the rubber sheet leading end, the end in the width direction to be the outside in the radial direction on the annular band is located closer to the front in a traveling direction of the long sheet than the end in a width direction to be an inside in the radial direction, while in the cut-off face of the rubber sheet rear end, the end in the width direction to be the outside in the radial direction on the annular band is located closer to the rear in the traveling direction of the long sheet than the end in the width direction to be the inside in the radial direction, and

a rubber sheet portion in a shape of a trapezoid or a triangle defined by the cut-off face of the rear end of the rubber sheet stamped first and the cut-off face of the leading end of the rubber sheet to be stamped next is removed.

4. (Currently Amended) A method of manufacturing a tire having, on at least one side wall, a first color side wall rubber expressed as characters or lines, second color side wall rubbers, each of which is located on both sides in the radial direction of this first color side wall rubber, and a second color cover rubber covering the first color side wall rubber portion other than the characters or lines, comprising:

winding a continuous second color rubber ribbon and a continuous first color rubber ribbon in plural turns to stamp each of the second color side wall rubbers and the first color side wall rubber on the side face of a carcass member formed in the toroidal state,

winding a rubber sheet in one turn in the annular state to stamp said cover rubber on the outside of the first and second side wall rubbers by winding so as to shape a green tire,

vulcanizing the green tire, using a mold having a recess portion corresponding to the characters or lines, and forming a projecting portion corresponding to the recess portion on the tire, and

after vulcanization, buffing the projecting portion on the tire to have the first color characters or lines to be expressed. ~~A method of manufacturing a tire according to claim 1,~~ wherein, in stamping said cover rubber onto the annular band on the side wall to be the stamping face, the rubber sheet extruded through a die is passed through a gap formed by arranging large-diameter sides and small-diameter sides of a pair of truncated conical rollers opposite to each other and rolled, and immediately after rolling of this rubber sheet, the rubber sheet is stamped in the annular state so that the rubber sheet side rolled by the large-diameter side of truncated conical roller is made to correspond with the outside in the radial direction of the annular band while the side rolled by the small-diameter side of truncated conical roller is made to correspond with the inside in the annular band.

5. (Original) A method of manufacturing a tire according to claim 4, wherein said gap is made uniform over the width direction when rolling the rubber sheet.

6. (Previously Presented) A method of manufacturing a tire according to claim 4, wherein after the rolled rubber sheet is wound around one of the truncated conical rollers by a predetermined angle, the rubber sheet is transferred from this truncated conical roller to the annular band while pressing the wound rubber sheet onto the side face of the carcass member.

7. (Previously Presented) A method of manufacturing a tire according to claim 4, wherein the rubber sheet wound around said one of the truncated conical rollers is cut off in the width direction on this truncated conical roller.

8-28. (Cancelled)